

Date: Wednesday, 5/31/2006 7:39:08 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ASPIRATOR ASS'Y
Job Number	: 27295		
Estimate Number	: 11909		
P.O. Number	: N/A	Part Number	: D2000047
This Issue	: 5/31/2006 S.O. No. : N/A	Drawing Number	: D2000047 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: A1
Previous Run	: N/A	Material	: N/A
Written By	: <u>See Comment Below</u>	Due Date	: 6/30/2006
Checked & Approved By	: <u>06.05.31</u>	Qty:	<u>10</u> Um: Each
Comment	: Est. C 02.03.05 Revised Pick List SM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2714	Washer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

1	D2714	Washer	B12164
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SB 06/07/06 (10)

2.0	D2000043	Jet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Jet

Pick:

Qty Part Number Description Batch

1	D2000-043	Jet	B22741
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MA 06/06/28 (10)

3.0	D2000109	Aspirator- Outer Flange
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Aspirator- Outer Flange

Pick:

Qty Part Number Description Batch

1	D2000-109	Aspirator	B27331
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MA 06/06/28 (10)

4.0	D2000111	Aspirator - Inner Core
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Aspirator - Inner Core

Pick:

Qty Part Number Description Batch

1	D2000-111	Aspirator	B27332
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MA 06/06/28 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ASPIRATOR ASS'Y

Job Number: 27295

Part Number: D2000047

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D30471

Screen Vent



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Screen Vent

Pick:

Qty Part Number Description Batch

1 D3047-1 Screen B17361

SB 06/07/11 10

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble jet D2000-043 in aspirator D2000-109 per dwg D2000

Weld jet D2000-043 in aspirator D2000-109 per dwg D2000

AA 06/06/28 10

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 06-06-23 10

8.0

HAND FINISHING

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Anodize Matte Black per QSI 017

issue P.O 1582

9.0

QC6

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-07-10 10

10.0 A

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble screen & washer as per dwg D2000

SB 06/07/11 10

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST196

AL 06/07/12 10

8A Receive & Inspect for transit damage

06/7/12 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-07-12	10	ADD QCS After Step 10 for Ass'y. Perm. change	E	06-07-12			06-07-12

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/07/13

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 5/31/2006 7:39:09 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ASPIRATOR ASS'Y

Job Number: 27295

Part Number: D2000047

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

Handwritten: 06/07/13 (1d)

Job Completion



Handwritten: U 06-0713

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

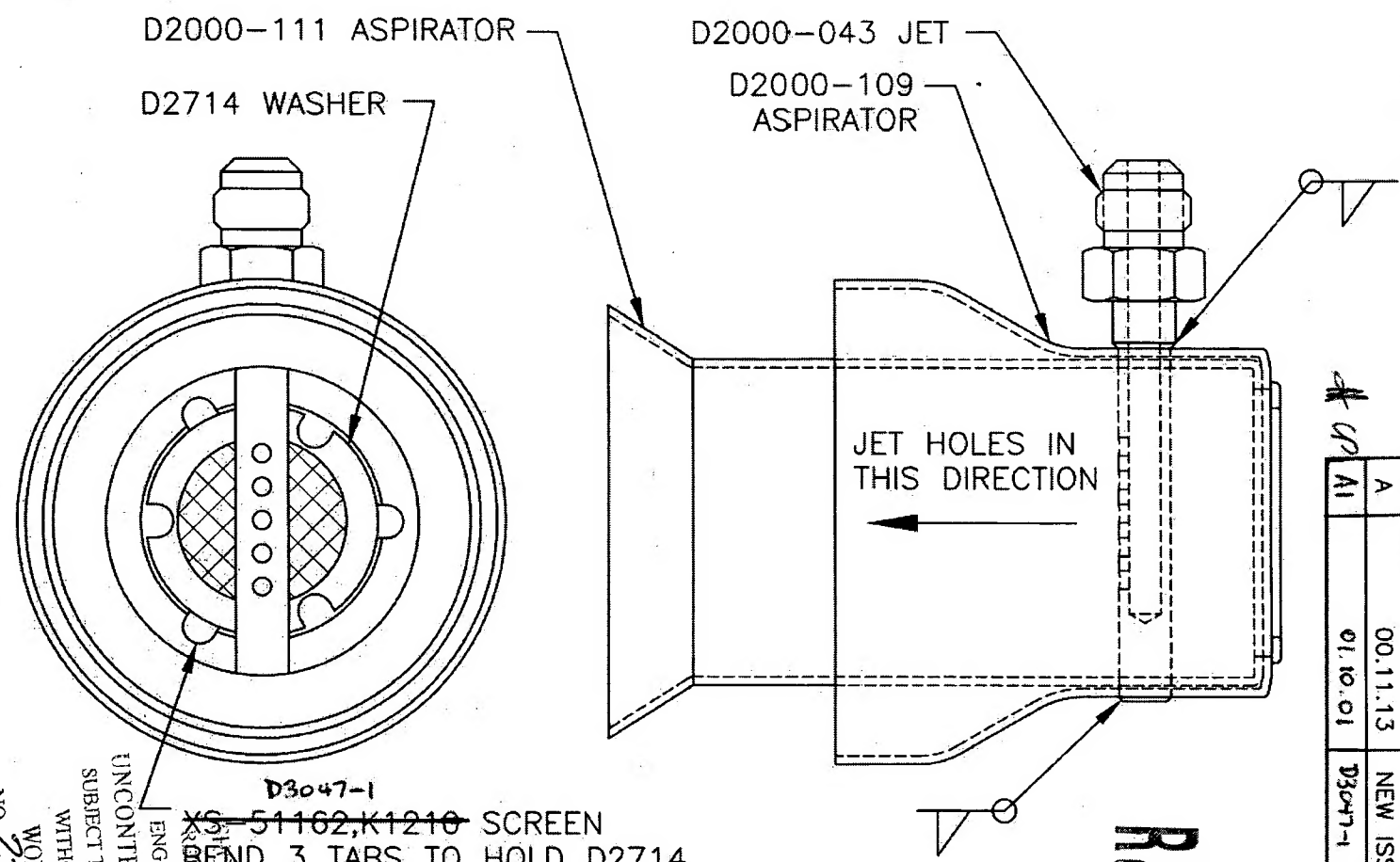
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	HAMKESBURY, ONTARIO, CANADA	
DATE		DRAWING NO.	REV. A
00.11.13		D2000-047	SHEET 1 OF 1
		TITLE	SCALE
		ASPIRATOR ASSEMBLY	1:1
A	00.11.13	NEW ISSUE	
AI	01.10.01	D3047-1 W45 XS-51162, K1210	



~~XS-51162, K1210~~ SCREEN
BEND 3 TABS TO HOLD D2714
WASHER. INSTALL IN ASPIRATOR AND
BEND REMAINING THREE TABS TO HOLD
IN PLACE AS SHOWN

NOTES:
WELD PER DART QSI 004
FINISH: ANODIZE MATTE BLACK PER MIL-A-8625F TYPE I OR IB OR IC
OR II OR IIB CLASS 2
INSTALL ~~XS-51162, K1210~~ SCREEN AND D2714 WASHER AFTER FINISH

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING

WORK ORDER
NO. 27295

TNM**ANODISATION et PEINTURE TNM INC.**

21 chemin de l'Aviation, QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / ISO 9001-2000 certified

Certifié NADCAP / NADCAP certified

**FACTURE
INVOICE****48592**

04-Jul-2006

**CLIENT / CUSTOMER:****DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

PURCHASE ORDER/**NO. DE COMMANDE:** 00001582**CONDITIONS / TERMS:****NET 30 JOURS / NET 30 DAYS**

ITEM	COMMANDE ORDERED	QUANTITE SHIPPED	PART NUMBER & DESCRIPTION	PRE UNITAIRE UNIT PRICE	EXTENSION
1	10	10	VARIOUS	\$0.00	\$0.00
			<i>LOT PRICE</i>		\$100.00
			SUB TOTAL:		\$100.00
			TPS/GST:		\$6.00
			TVQ/PST:		\$0.00
			TOTAL AMOUNT DUE:		\$106.00

**PLEASE DISREGARD THE PREVIOUS INVOICE, PRICE
AMENDED, WRONG P.O. SENT TO US (PO00001386)**

No de TPS / GST # : 891559734 RT

CERTIFICAT DE CONFIRMITE EMIS POUR CHAQUE PROCEDURE

No de TVQ / QST # : 1019307154 TQ000

CERTIFICATE OF COMPLIANCE ISSUED FOR EACH PROCESS

En cas de perte ou de dommages dû a la la valeur intrinsèque de certaines responsabilité se limitera à deux fois la valeur du traitement des pieces perdues ou endommagées.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.

TNM**ANODISATION et PEINTURE TNM INC.**

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / AS9100 certified

approuvé NADCAP approved

48592

04-Jul-2006

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

**CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE****PURCHASE ORDER/
NO. DE COMMANDE** 00001582

ITEM	QUANTITY ORDERED	QUANTITY SHIPPED	ITEM NUMBER	DESCRIPTION	PROCESS / TREATMENT
1	10	10	D2000-047	B27295	MATL: AL BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ✓

REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MD-INC P.R.I.D.E. MANUAL

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.
Travel cards have been filed and are available for viewing upon request.

Signature/Signed: _____

[] Directeur de la Qualité / Q.A. Manager []



TNM**ANODISATION et PEINTURE TNM INC.**

21 chemin de l'Aviation, QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / ISO 9001-2000 certified

Certifié NADCAP / NADCAP certified

PACKING
SLIP

48592

04-Jul-2006

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

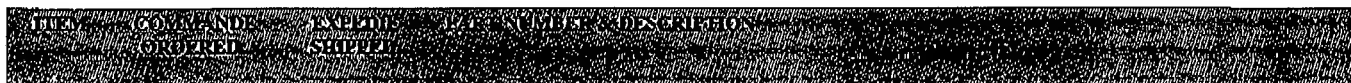
1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

PURCHASE ORDER/**NO. DE COMMANDE:**

00001582



QUANTITY	COMMANDE	REPERES	DATE	NUMERO	DESCRIPTION
1	10	10	VARIOUS	VARIOUS	

PICKED UP BY / RECU:

signed 2006-07-07

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